

Date: Tuesday, 8/1/2006 11:28:29 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L AFT X-TUBE
 Job Number : 28059
 Estimate Number : 10973
 P.O. Number :
 This Issue : 8/1/2006 S.O. No. :
 Prsht Rev. : NC Drawing Number : D206-667-243 REV B
 First Issue : / / Type : LANDING GEAR Project Number : N/A
 Previous Run : 28058 Drawing Revision : B
 Material :
 Due Date : 8/31/2006 Qty: 1 Um: Each
 Written By : KG 06 08.01
 Checked & Approved By :
 Comment : Est Rev: F 05.09.01 Add holes for compatibility with Bell
 Skid tubes KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-203 CHG002

2.0

D6004115

Crosstube material



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number

Description Batch

1 D6004-115

Crosstube

25664

Check OD = 2.500"; ID = 1.800"

Bg 06-08-23 1

3.0

MORI SEIKI

MORI SEIKI CNC-LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA089

2-Turn first side as per Folio FA089

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243.

Bg 06-08-23 1

4.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

Bg 06-08-23 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06.08.23	3	Cuff on one side is ovalized 2.442/2.403	UP 06.08.23 per QSI 042	Part is OK per attached DS-email: Bend so small dimension ORIENTED WITH BEND See email		J 06.09.06	UP 06.08.23 per QSI 042	J 06.09.06

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 8/1/2006 11:28:30 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 28059

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA089

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243.

3-Polish entire outside surface of crosstube (done in ^{landing gear} finishing)

4-Remove sand and plugs

5-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-243

BC 06-08-23

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

BC 06-08-23

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

MB 06/08/24

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

2 + 06 08 23

9.0

BENDING

BENDING MACHINE



★ see attached email
for ORIENTATION



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-243 using CNC bender program 206L-AF and Folio FT _____

Ph.
06-08-24 (1)

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

J 06-09-06 (1)

11.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1




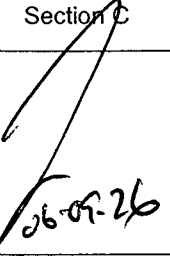

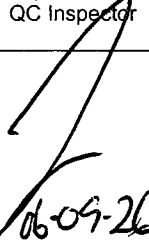


Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-09-26	11.1	Employee placed the rivet hole drill jig upside down drilling the holes in the wrong location, too close to the b.g holes; not in the center. 	 06/09/26	tube scrap for production, but can be used for engine- ering drop test.	 06-10-3	 06-09-26	 06/09/26	 06-09-26

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 8/1/2006 11:28:30 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 28059

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243

6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8789 as per Dwg D206-667-243.

8-C'sink holes as per Dwg D206-667-243.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

15.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: _____

LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 8/1/2006 11:28:30 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 28059

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

18.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045 Nut Plate _____

19.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043 Nut Plate _____

20.0

MS20601AD4W10

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W10 Rivet _____

21.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install nut plates as per Dwg D206-667-243.

22.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Mask Threaded holes

2-Prime inside and outside crosstube as per QSI 005 4.2

3-Paint outside crosstube with White Imron as per QSI 005 4.2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

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Date: Tuesday, 8/1/2006 11:28:30 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 28059

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

24.0

D2856400

Abrasion Strip



Comment: Qty.: 1.3525 f(s)/Unit Total : 1.3525 f(s)

Pick:

Qty Part number Description Batch

2 D2856-400(Cut to 7.73") Abrasion Strip

25.0

D28921

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2892-1 Support

26.0

MS2192022

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-22 Clamp

27.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8580. .Note: (3) top holes should be facing up.

2-Install supports and clamps as per Dwg D206-667-243. Torque clamps to 80-100 in lb

28.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

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Date: Tuesday, 8/1/2006 11:28:30 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 28059

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

30.0

AN534A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: _____

31.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: _____

32.0

AN510A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

10 AN5-10A

Bolt _____

33.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

4 AN5-32A

Bolt _____

34.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

18 AN960JD516

Washer _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 8/1/2006 11:28:30 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 28059

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

36.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-203

Location: _____

PPP Rev: _____

37.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Ln D206-061

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED # DS	APPROVED # DS	DRAWING NO. D206-667-243	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH AFT)	SCALE NTS
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05 07 26 #

Qty	Part Number	Description
X	D206-667-243	CROSSTUBE ASSEMBLY
1	D6004-115	CROSSTUBE
2	D2856-400-773	ABRASION STRIP
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2892-1	SUPPORT
14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
4	MS21920-22	CLAMP

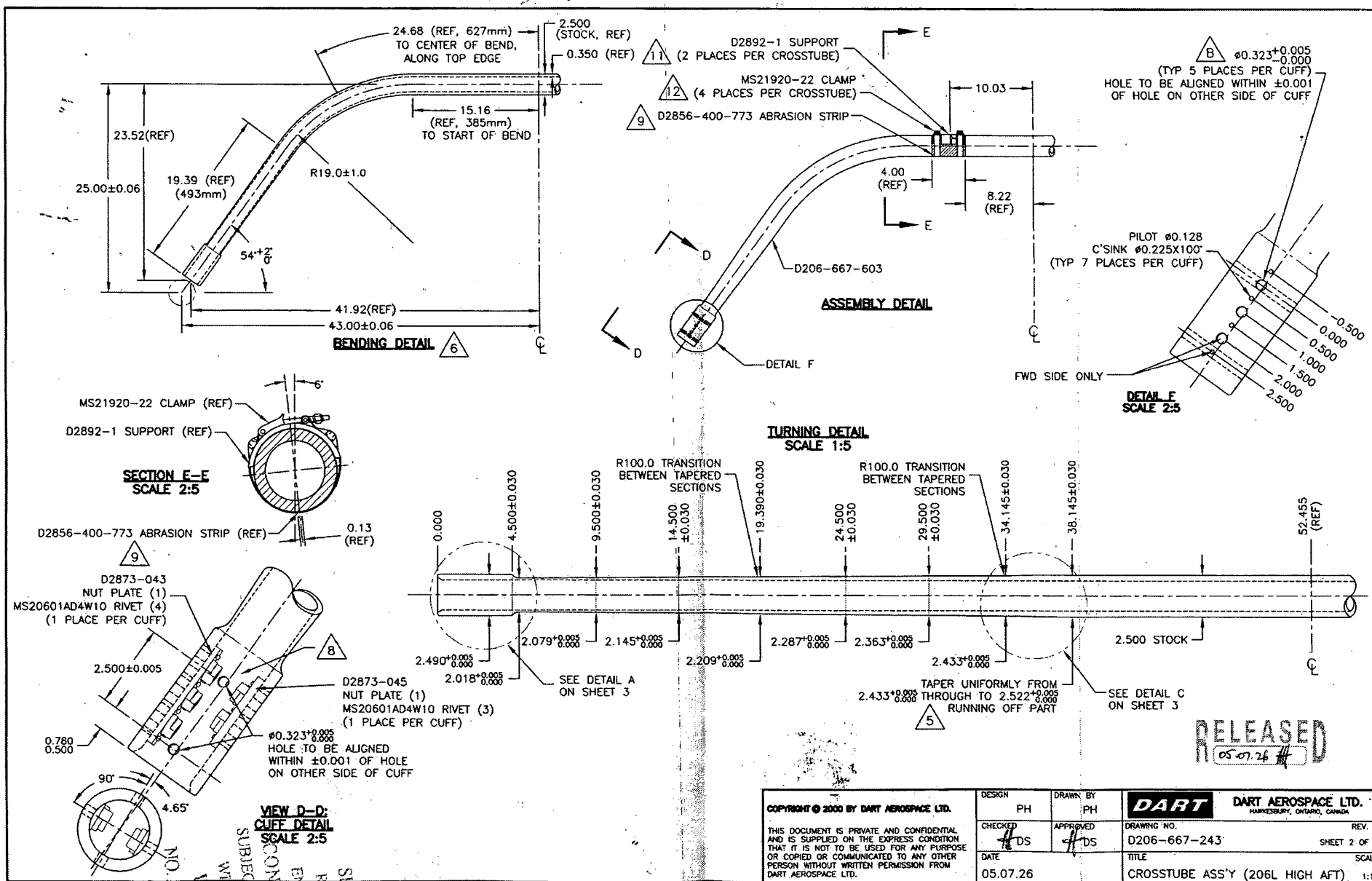
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6004-115
FINISHED LENGTH = 104.91±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2892-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

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RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28057

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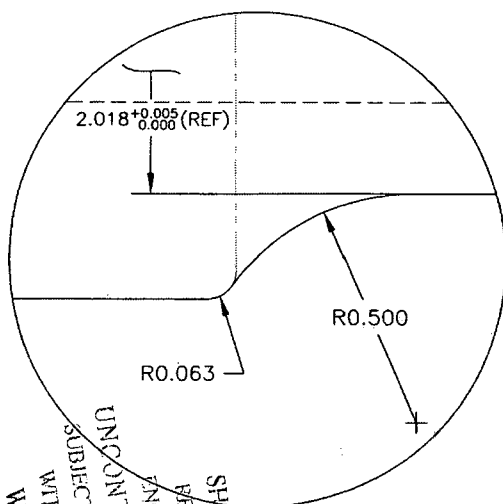
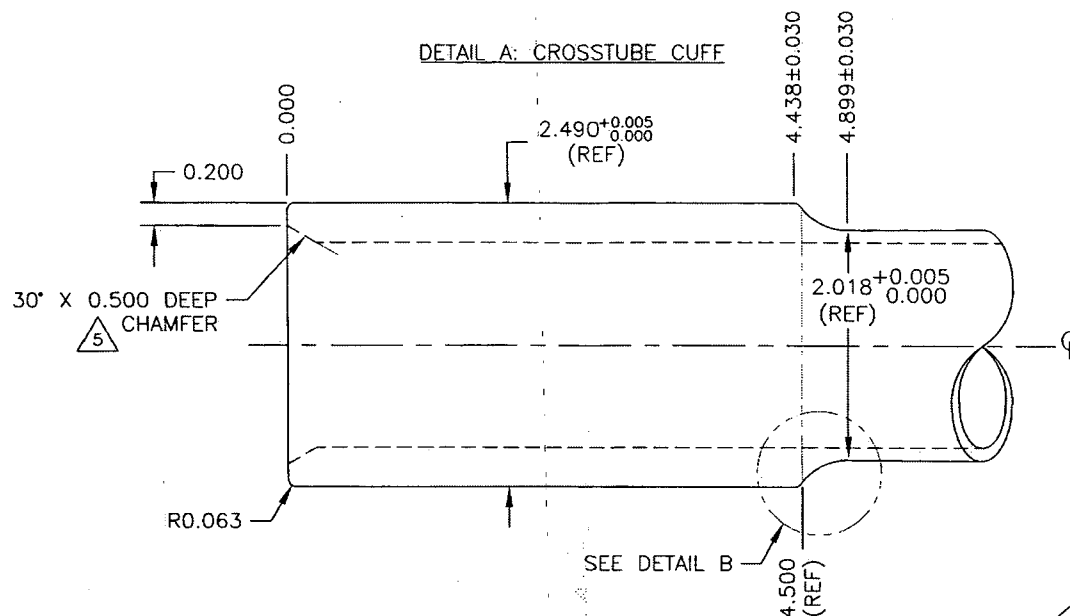
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 05-07-26

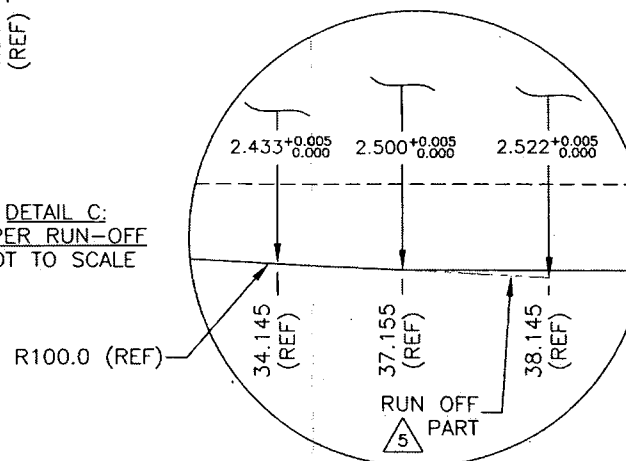
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		DATE	05.07.26			D206-667-243	SHEET 2 OF 3
		TITLE	CROSSTUBE ASS'Y (206L HIGH AFT)		SCALE	1:10	

RELEASED
05.07.26



DETAIL B: CUFF
TRANSITION
SCALE 4:1

DETAIL C:
TAPER RUN-OFF
NOT TO SCALE



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DATE		05.07.26		DRAWING NO.		D206-667-243	SCALE
				TITLE		CROSSTUBE ASS'Y (206L HIGH AFT)	1:1

NO. 28059
WORK ORDER
SUBJECT TO AMENDMENT
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ENGINEERING
SHOP COPY

DART AEROSPACE LTD	Work Order: 28059
Description: Crosstube Assembly	Part Number: 0206667203
Inspection Dwg: 0206667-243 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.490	+0.005 -0.000	2.492/2.483		X	extrusion v/s
	2.018	+0.005 -0.000	2.022	✓		
	2.079	+0.005 -0.000	2.083	✓		
	2.145	+0.005 -0.000	2.148	✓		
	2.209	+0.005 -0.000	2.212	✓		
	2.287	+0.005 -0.000	2.290	✓		
	2.363	+0.005 -0.000	2.365	✓		
	2.433	+0.005 -0.000	2.438	✓		
	0.200	+/- 0.010	.200	✓		
	0.500 X 30°	+/- 0.010	.500	✓		
	Ro.063	+/- 0.010	.063	✓		
	Ro.500	+/- 0.010	.500	✓		
	4.438	+/- 0.030	4.438	✓		
SIDE B	104.91	+/- 0.020	104.91	✓		
	2.490	+0.005 -0.000	2.491	✓		
	2.018	+0.005 -0.000	2.023	✓		
	2.079	+0.005 -0.000	2.084	✓		
	2.145	+0.005 -0.000	2.150	✓		
	2.209	+0.005 -0.000	2.214	✓		
	2.287	+0.005 -0.000	2.291	✓		
	2.363	+0.005 -0.000	2.367	✓		
	2.433	+0.005 -0.000	2.438	✓		
	0.200	+/- 0.010	.200	✓		
	0.500 X 30°	+/- 0.010	.500	✓		
	Ro.063	+/- 0.010	.063	✓		
	Ro.500	+/- 0.010	.500	✓		
	4.438	+/- 0.030	4.438	✓		

Measured by: BF	Audited by: MB	Prototype Approval:	N/A
Date: 06.08.23	Date: 06/08/24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.12.12	New Issue	KJ/RF	

Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]

Sent: August 23, 2006 12:54 PM

To: 'Chris Provencal'

Subject: RE: NCR for D206-667-243

Chris,

I agree with your assessment.

The tube is acceptable and they should bend it so that it is oriented as you have proposed.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]

Sent: Wednesday, August 23, 2006 9:51 AM

To: 'David Shepherd'

Subject: NCR for D206-667-243

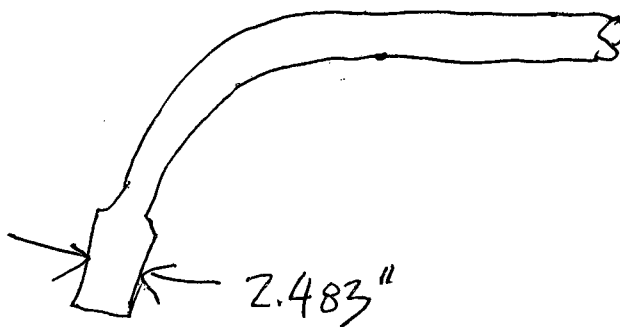
David,

One D206-667-243, the stock material was slightly ovalized. As a result the cuff is 2.492 / 2.483 (2.490 is the min). Is this part OK?

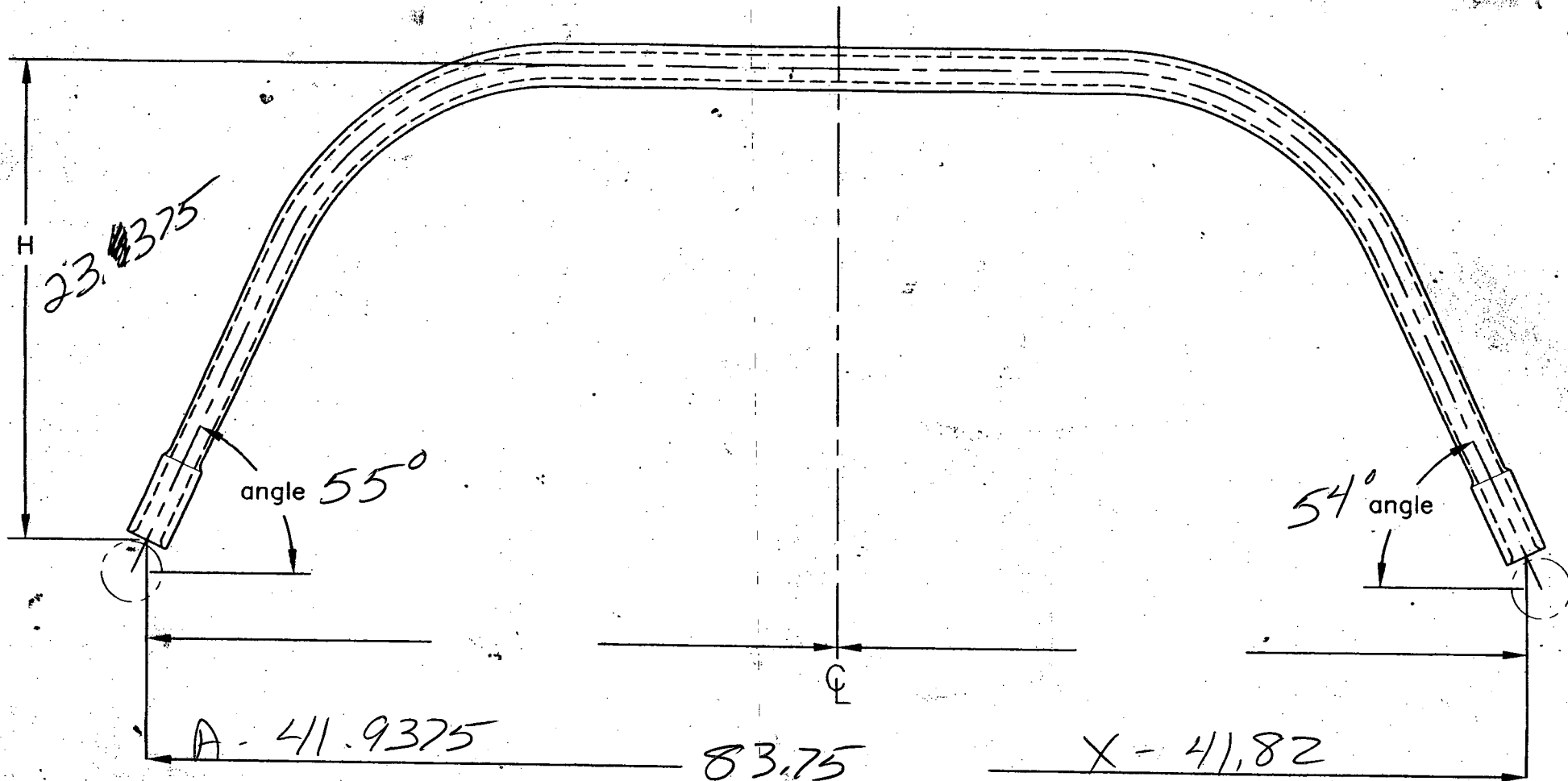
If I remember correctly, we've OK'd this before and had them bend the tube so the narrow direction was oriented with the bend. Thus, the saddle holes went through the narrow direction to eliminate the possibility of the saddle being overstressed when the flanges were bolted-up.

They want to bend this tube asap.

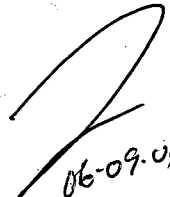
-Chris



CP 06.08.23



DATE: 6-9-6
 DESCRIPTION: B28059 / D206-667-203
 BATCH NO: B28059
 DRAWING: D206-667-243 Rev B
 H: 23.4375
 1/2 SPAN: 41.92
 TOTAL SPAN: 83.84
 ANGLE: 54° +2
 -0


 06-09-06

